

Date: Friday, 17/10/2008 9:06:50 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: HEADREST ADAPTER
Job Number	: 42711		
Estimate Number	: 13333		
P.O. Number	:	Part Number	: D3773041
This Issue	: 17/10/2008 S.O. No. :	Drawing Number	: D3773 REV B
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 40980	Material	:
Written By	:	Due Date	: 24/10/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>MF 08-10-17</u>		
Comment	: Est Rev:A 08-05-21 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC		

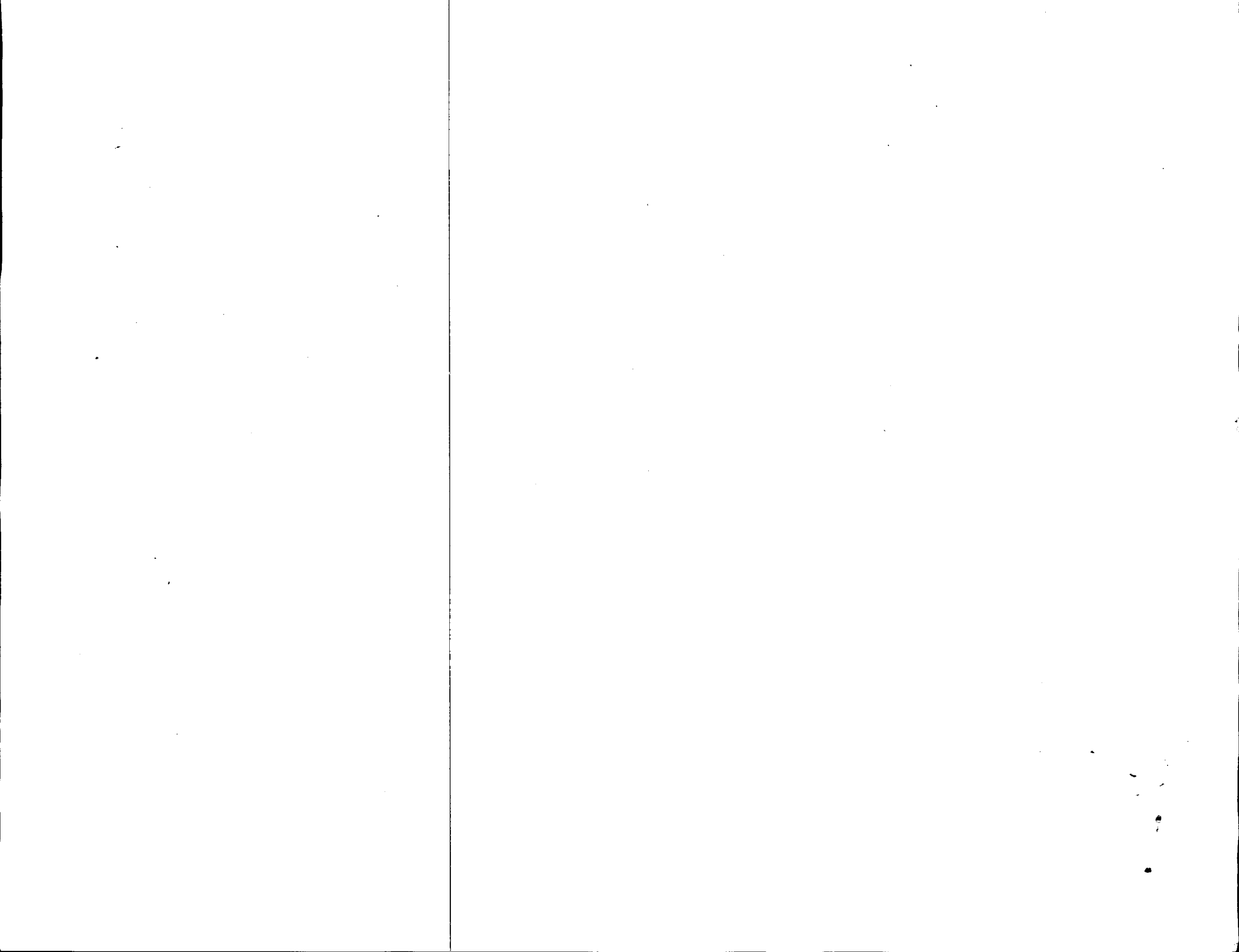
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D37731	Adapter
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Adapter batch: <u>B 40996</u> SP 08.12.04	
3.0	D37733	Leg
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Leg batch: <u>B 40997</u> SP 08.12.04	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773 ****take dowel pin out before welding**** 2- weld as per dwg D3773 QSI004 316 S.S. Welding Rod Batch: <u>M.106762</u> 3- if necessary grind interior of D3773-3 leg flush after welding SP 08.12.04	

(6X)



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Drawing Name: HEADREST ADAPTER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/12/08 (x6)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

QC 08.12.08

(x6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57245

JS 08/12/08 (x6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



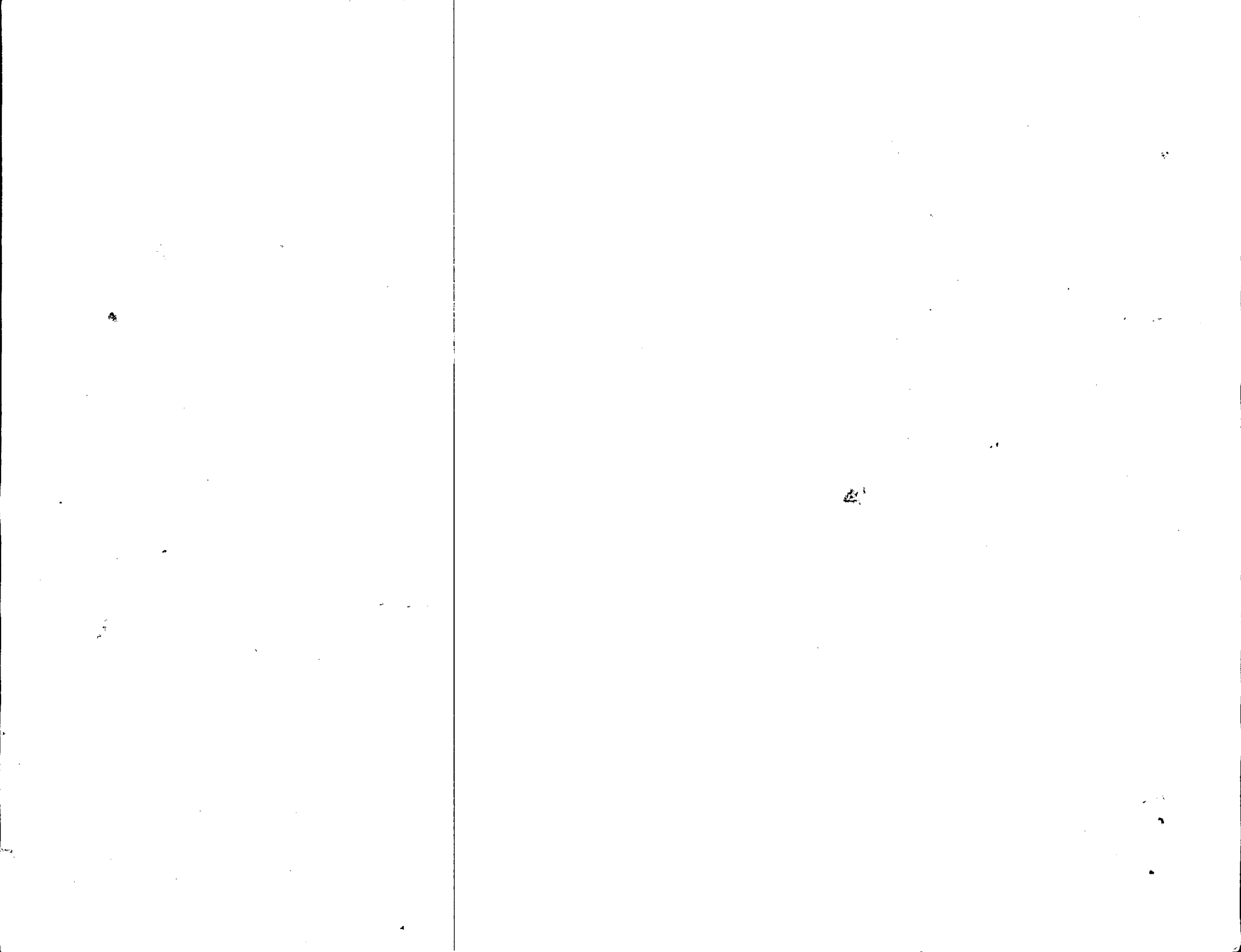
Comment: FINAL INSPECTION/W/O RELEASE

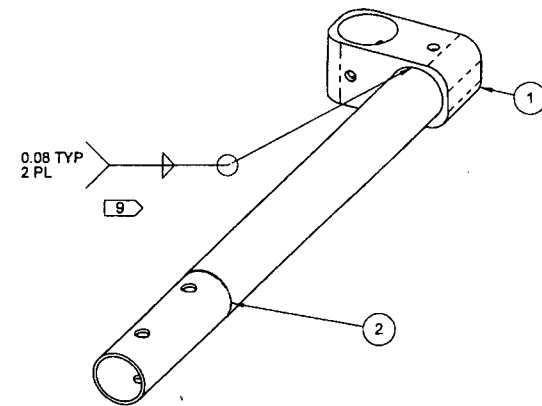
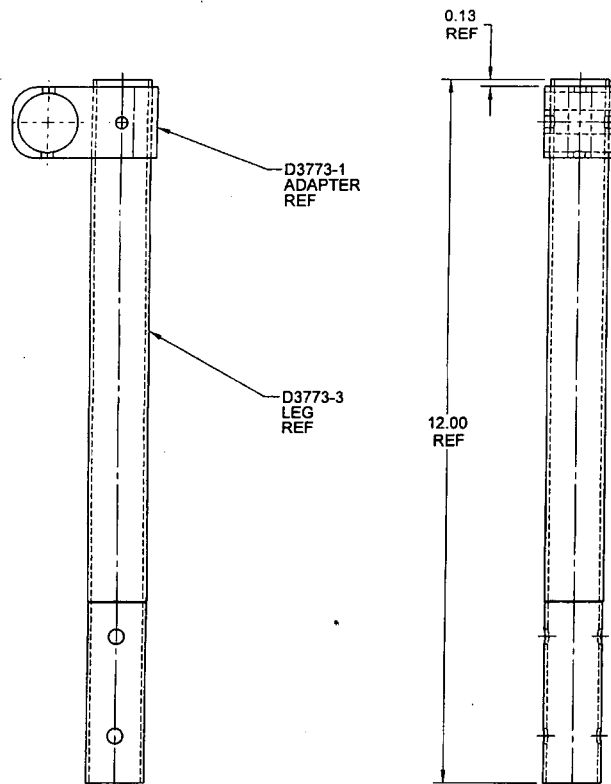
08/12/09

Job Completion



MF 08-12-08





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

NOTES:

- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

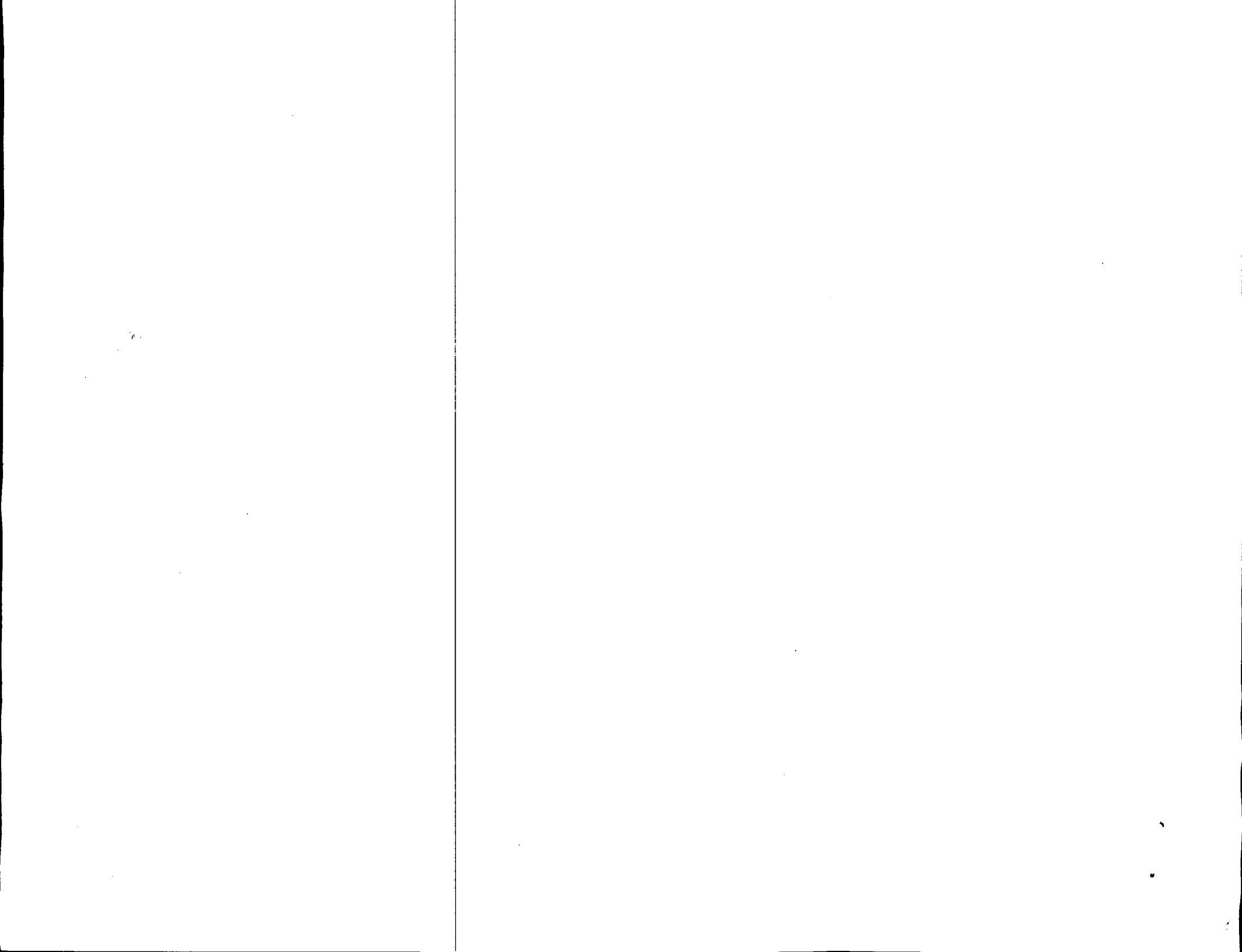
D3773-041 HEADREST ASSEMBLY

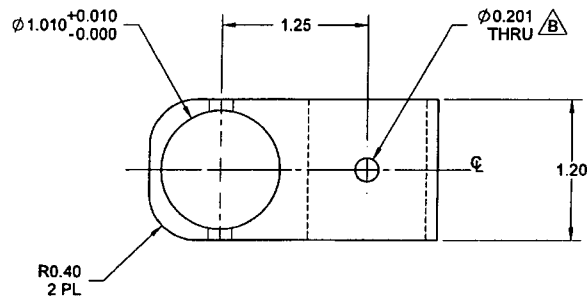
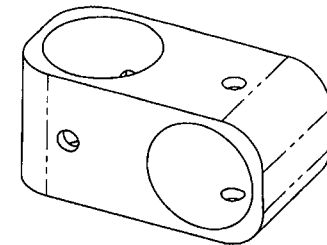
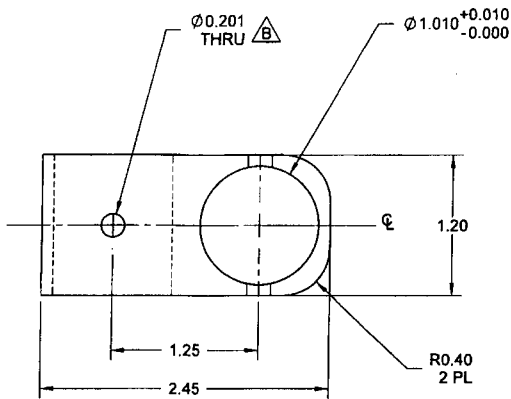
B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3773** REV. B
SHEET 1 OF 3
TITLE **HEADREST ADAPTER** SCALE NTS

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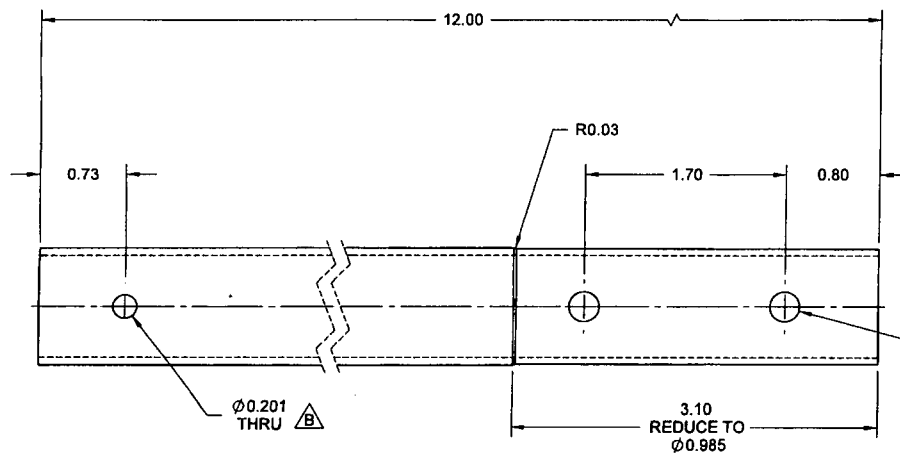


D3773-1 ADAPTER

NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3773	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	NTS
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Ø0.257
THRU
2 PL

Ø0.985^{+0.000}
-0.010

Ø1.000
REF

0.065
REF

3.10
REDUCE TO
Ø0.985

D3773-3 LEG

- NOTES:
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

#42711

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3773	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	HEADREST ADAPTER	NTS
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